

**Final Report**

**on the Four-Month Extension of MURI contract N00014-96-1-1223**

**"High Power, Broadband, Linear, Solid State Amplifier"**

**For the period:**

**September 1 – December 31, 2001**

**Sponsored by:**

**Office of Naval Research  
John Zolper, Monitor**

**Submitted by:**

**Lester F. Eastman, P.I.  
Cornell University  
School of Electrical and Computer Engineering  
425 Phillips Hall  
Ithaca, NY 14853-5401  
TEL: (607) 255-4369  
FAX: (607) 255-4742  
e-mail: [lfe@eeiv.tn.cornell.edu](mailto:lfe@eeiv.tn.cornell.edu)**

**January 2002**

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**20020129 058**

# REPORT DOCUMENTATION PAGE

Form Approved  
OMB No. 0704-0188

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1. AGENCY USE ONLY (Leave Blank)	2. REPORT DATE Jan. 30, 2002	3. REPORT TYPE AND DATES COVERED Final 4 months extension (9-1-12/31/2001)
4. TITLE AND SUBTITLE High power, broadband, linear, solid state amplifier		5. FUNDING NUMBERS MURI N0001-96-1-1223
6. AUTHORS Lester F. Eastman, contract P.I.		
7. PERFORMING ORGANIZATION NAME(S) AND ADDRESS(ES) Cornell University, Elec. and Computer Eng. 425 Phillips Hall, Ithaca, NY 14853-5401		8. PERFORMING ORGANIZATION REPORT NUMBER none
9. SPONSORING / MONITORING AGENCY NAME(S) AND ADDRESS(ES) Office of Naval Research, Dr. John Zolper 800 N. Quincy Street, ONR 312, Room 607 Arlington, VA 22217-5660		10. SPONSORING / MONITORING AGENCY REPORT NUMBER none

11. SUPPLEMENTARY NOTES This MURI contract was scheduled to end on August 31, 2001. However, as prime contractor, Cornell had not yet met its obligations on cost sharing. A request was made, and approved, for a no-cost extension to December 31, 2001, to meet its obligation with industrial grants.

12a. DISTRIBUTION / AVAILABILITY STATEMENT General available to the public	12b. DISTRIBUTION CODE
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## 13. ABSTRACT (Maximum 200 words)

This report only covers the four months extension period of this contract. The summary report of the earlier five year effort is attached.

During the extension period the undoped AlGaIn/GaN material structure was modified to include a thin AlN layer at the heterojunction. A 15.3 Å layer was optimum for confinement of carriers and low ohmic contact transfer resistance. HEMT's with this structure showed promise, with 1.5 A/mm channel current, but the .30 µm gate broke down at pinch-off with 25 V drain-source bias. Without the AlN layer, HEMT's with 1.2 A/mm channel current could be biased to drain-source voltage of 45 V, and reached new state-of-the-art performances of 11.7 W/mm at 10 GHz with .3 µm gates, and 2.32 W/mm at 35 GHz with .12 µm gates.

14. SUBJECT TERMS microwave transistor, Gallium nitride, MBE OMVPE and bulk growth power combining circuits			15. NUMBER OF PAGES 10
			16. PRICE CODE
17. SECURITY CLASSIFICATION OF REPORT unclassified	18. SECURITY CLASSIFICATION OF THIS PAGE unclassified	19. SECURITY CLASSIFICATION OF ABSTRACT unclassified	20. LIMITATION OF ABSTRACT UL

NSN 7540-01-280-5500

Standard Form 298 (Rev. 2-89)  
Prescribed by ANSI Std. Z39-1  
298-102

## **I. Introduction**

During the period from September 1 – December 31, 2001, effort continued on this MURI contract, after an approved extension, using unrestricted grants from industry. This report briefly covers the highlights of the program during this period. The two key areas covered are the undoped materials growth, and the AlGa<sub>N</sub>/Ga<sub>N</sub> HEMT performance.

## **II. Materials growth and characterization**

Using the flow modulation epitaxy mode of OMVPE growth in the Cornell vertical barrel reactor, the undoped AlGa<sub>N</sub>/Ga<sub>N</sub> HEMT wafers were grown. The growth was on SiC substrates, at a substrate temperature of 1040° C and a pressure near 10% of atmospheric pressure. Sequentially, an Al<sub>x</sub>Ga<sub>1-x</sub>N nucleation layer, ~ 200 Å thick, with x in the .05 - .10 range, then an AlN sub-buffer, 2,000 Å thick, then the Ga<sub>N</sub> buffer/channel layer, and finally the undoped Al<sub>y</sub>Ga<sub>1-y</sub>N top barrier layer were grown. The standard top barrier layer has .30 < y < .40, with a thin AlN layer on top of the Ga<sub>N</sub> buffer/channel layer in some cases. The thickness of this layer was determined to be near optimum when it was 15.3 Å (6 molecular layers), with 7.65 Å being too thin, and 22.95 Å being too thick. When only 7.65 Å thick, electrons tunneled through it, under a small positive gate bias, not allowing the required confinement to the channel. When it was 22.95 Å thick, the annealed ohmic contact transfer resistances at the source and drain were substantially higher than the .3 - .50 Ω-mm usually obtained. In order to control the thickness, growth rates were calibrated in terms of the number of molecular layers of AlN deposited during each rotation of the susceptor

(in and out of the TMA region), and then rotations were counted to achieve the specific AlN thickness. One wafer was grown with 200 Å of  $\text{Al}_{.39}\text{Ga}_{.61}\text{N}$  as the top region of the barrier, and 15.3 Å of AlN between that region and the GaN buffer/channel region. The average 2DEG electron sheet density in that wafer was  $1.6 \times 10^{13}/\text{cm}^2$ . This electron sheet density was appreciably higher than the  $1.0 - 1.2 \times 10^{13}/\text{cm}^2$  present in our usual, high-performance wafers.

### III. AlGaN/GaN HEMT device fabrication and testing

The HEMT's were fabricated by our standard process of annealed ohmic contacts yielding .3 - .5  $\Omega$ -mm contact transfer resistance, and with mushroom-shaped cross-section gates with .3  $\mu\text{m}$  and .12  $\mu\text{m}$  gate footprints. A center-fed, single 100  $\mu\text{m}$  wide device yielded a new state-of-the-state of CW power density of 11.7 W/mm with 42% power-added efficiency at 10 GHz using the .3  $\mu\text{m}$  gates. HEMT's with .12  $\mu\text{m}$  gates yielded the state-of-the-art of CW power density of 2.32 W/mm with 22% power-added efficiency at 35 GHz.

Experiments at 10 GHz, with 10 channels, each with .3  $\mu\text{m} \times 150 \mu\text{m}$  gates were done with different gate pitches. Our usual gate pitch of 50  $\mu\text{m}$  was used as a reference. If the pitch was raised to 75  $\mu\text{m}$ , the power-added efficiency and the output power rose by a few percent. When the pitch was raised to 100  $\mu\text{m}$ , the power-added efficiency dropped by 25-30%, even though the channels should be running cooler with such large pitch. The effect of phase differences in the output currents from the different channels was analyzed to explain this efficiency difference. It was then determined

that the total gate and drain phase increment between currents in adjacent channels was  $33^\circ$  for 10 GHz operation, and 50  $\mu\text{m}$  pitch. This phase difference rises linearly with frequency, and as the square root of the pitch.

Devices made with the 15.3  $\text{\AA}$  AlN layer between the  $\text{Al}_{0.39}\text{Ga}_{0.61}\text{N}$  barrier and the GaN buffer/channel layer were also tested. They yielded a high (1.5 A/mm) normalized channel current, but had a gate breakdown at pinch-off if the drain-source voltage exceeded 25 V. The high electric field under the gate, due to the high gate-source pinch-off voltage, coupled with the contribution to this electric field by the drain-source bias, appears to be the cause of this gate breakdown, based on a simple tunneling analysis.

Finally, monolithic VCO and narrow-band amplifiers were fabricated and given preliminary tests. The Varactor for the VCO used a HEMT structure. The narrow-band amplifier used on-chip second harmonic tuning, which experimentally missed the design frequency that would be twice the 10 GHz fundamental frequency design, in this first test.

### **III. Student employment and technology transfer**

Students trained on this MURI have taken positions at Raytheon, BAE North America, Lucent Bell Laboratories, CREE, ATMI, Motorola, H.P., Nova Crystals, EMCORE, and RF Nitro Communications. The latter, located in Charlotte, NC was a new Cornell-based start up marketing AlGaIn/GaN HEMT wafers. It has recently been purchased by RF Micro Devices and continues the marketing of materials and devices. Various aspects of the Cornell AlGaIn/GaN HEMT technology are also being transferred to Northrop Grumman, Raytheon, GE/CRD, BAE North America, EMCORE, RF Micro Devices, Motorola, Triquint, and Rockwell.

## V. Conclusion

This report ends the present contact. Work continues funded by several small grants from industry. In general, the program was highly successful, achieving reproducible high quality material and fabrication methods, including the invention of the use of  $\text{Si}_3\text{N}_4$  on the exposed surface of the device semiconductor, to stop the current slump from surface state charging. State-of-the-art CW power density, about an order of magnitude higher than that of other materials resulted, and the students trained, along with the key technology areas, are being transferred to industry. A copy of the summary final report, submitted earlier after the conclusion of the initial five-year MURI effort, is attached.